

Work Order ID 79342

79342

Page 1

Wednesday, January 25, 2012 11:59:16 AM

Item ID: D4106-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crew Door Doulber, LH
 Start Date: 1/25/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 2/3/2012 Req'd Qty: 8.00 ***8*** Customer:

Reference:

Approvals: Process Plan: N.L.J Date: 12/01/25 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4106	A								

100 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg
 304 .050 Dwg Rev: A
 Prog Rev: A
 2-Deburr if necessary
 110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

B12-2-21
 B12-2-21

(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130									
Small Fab	Memo	0.00							
Small Fab	1- C'sink holes as per dwg								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

12 - 02 - 21 (9)

12/02/23 (9)

12 - 02 - 23 (9)

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Page 3

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Required Date: 2/3/2012 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>127</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/27 (9)

12/27 127 127

12/27

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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 25, 2012 11:59:21 AM

Page 1

Work Order ID: 79342

79342

Parent Item: D4106-3

D4106-3

Parent Item Name: Crew Door Doulber, LH

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	468.0050	0.2006	1.689263			
M304S18GA									**	B12-2-21			
304/316 .050 Sheet													

Location

Loc Qty

Loc Code

MAT020

468.005

119032

49.3

119383

96

119766

66.705

120243

256

119766

9

Dart Aerospace Ltd

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	79342
Description: Crew Door Doubler, LH		Part Number:	D4106-3
Inspection Dwg: D4106 Rev: A		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.131	2		V IB02	
Ø0.375	+0.006/-0.001	.376	2		V	
1.16	+/-0.030	1.161	2		V	
2.05	+/-0.030	2.051	2		V	
2.86	+/-0.030	2.860	2		V	
3.37	+/-0.030	3.370	2		V	
3.48	+/-0.030	3.480	1		V	
3.87	+/-0.030	3.869	2		V	
4.57	+/-0.030	4.568	2		V	
5.07	+/-0.030	5.066	2		V	
5.37	+/-0.030	5.361	2		V	
1.00	+/-0.030	1.004	2		V	
1.85	+/-0.030	1.853	2		V	
2.37	+/-0.030	2.371	2		V	
2.72	+/-0.030	2.718	2		V	
0.254	+/-0.010	.256	2		V	
3.20	+/-0.030	3.198	2		V	
0.508	+/-0.010	.506	2		V	
3.35	+/-0.030	3.353	2		V	
3.99	+/-0.030	3.996	2		V	
4.57	+/-0.030	4.573	2		V	
0.25	+/-0.030	.251	4		V	
0.25	+/-0.030	.252	2		V	
1.04	+/-0.030	1.041	2		V	
1.84	+/-0.030	1.840	2		V	
2.45	+/-0.030	2.454	2		V	
2.63	+/-0.030	2.628	2		V	
2.94	+/-0.030	2.943	2		V	
3.42	+/-0.030	3.424	2		V	
3.93	+/-0.030	3.936	2		V	
4.03	+/-0.030	4.037	2		V	
4.21	+/-0.030	4.211	2		V	
4.71	+/-0.030	4.708	2		V	
4.79	+/-0.030	4.791	2		V	
5.01	+/-0.030	5.011	2		V	
5.13	+/-0.030	5.130	2		V	
5.67	+/-0.030	5.668	1		V	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	10.10.07	New Issue	KJ 	

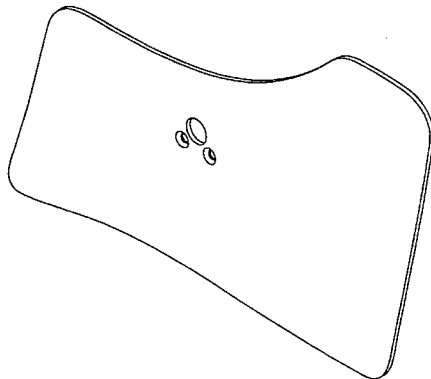
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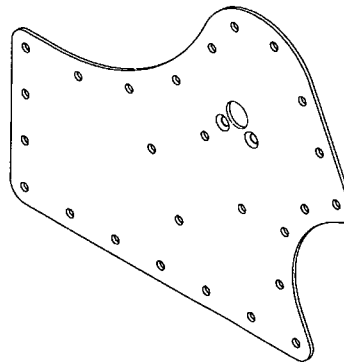
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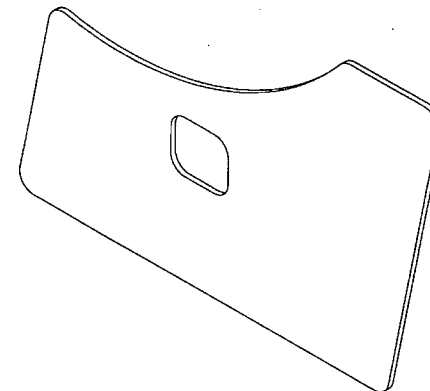
NOTE: Date & initial all entries



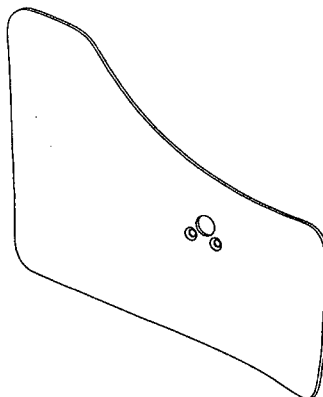
D4106-1 SILL DOUBLER, LH



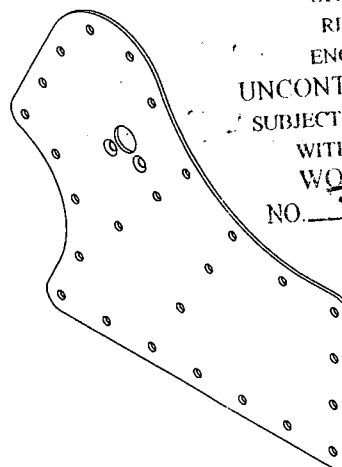
D4106-3 CREW DOOR DOUBLER, LH



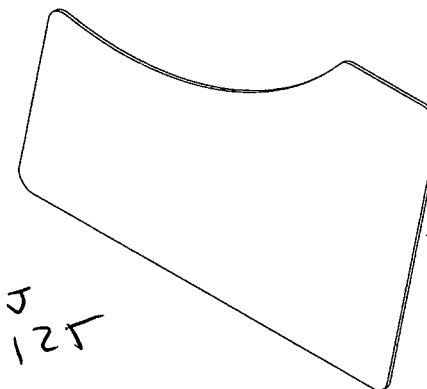
D4106-5 SPACER, SILL DOUBLER



D4106-2 SILL DOUBLER, RH






D4106-4 CREW DOOR DOUBLER, RH



D4106-7 TEMPLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 79342 M.L.J
12/01/25

RELEASED
2010-09-23
JPH

A		NEW ISSUE		JPH	10.07.15	
REV.		DESCRIPTION			BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
DRAWN	JPH					
CHECKED		DRAWING NO.	REV. A			
MFG. APPR.		D4106	SHEET 1 OF 5			
APPROVED		TITLE	SCALE			
DE APPR.		DOUBLERS	NTS			
DATE	10.07.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

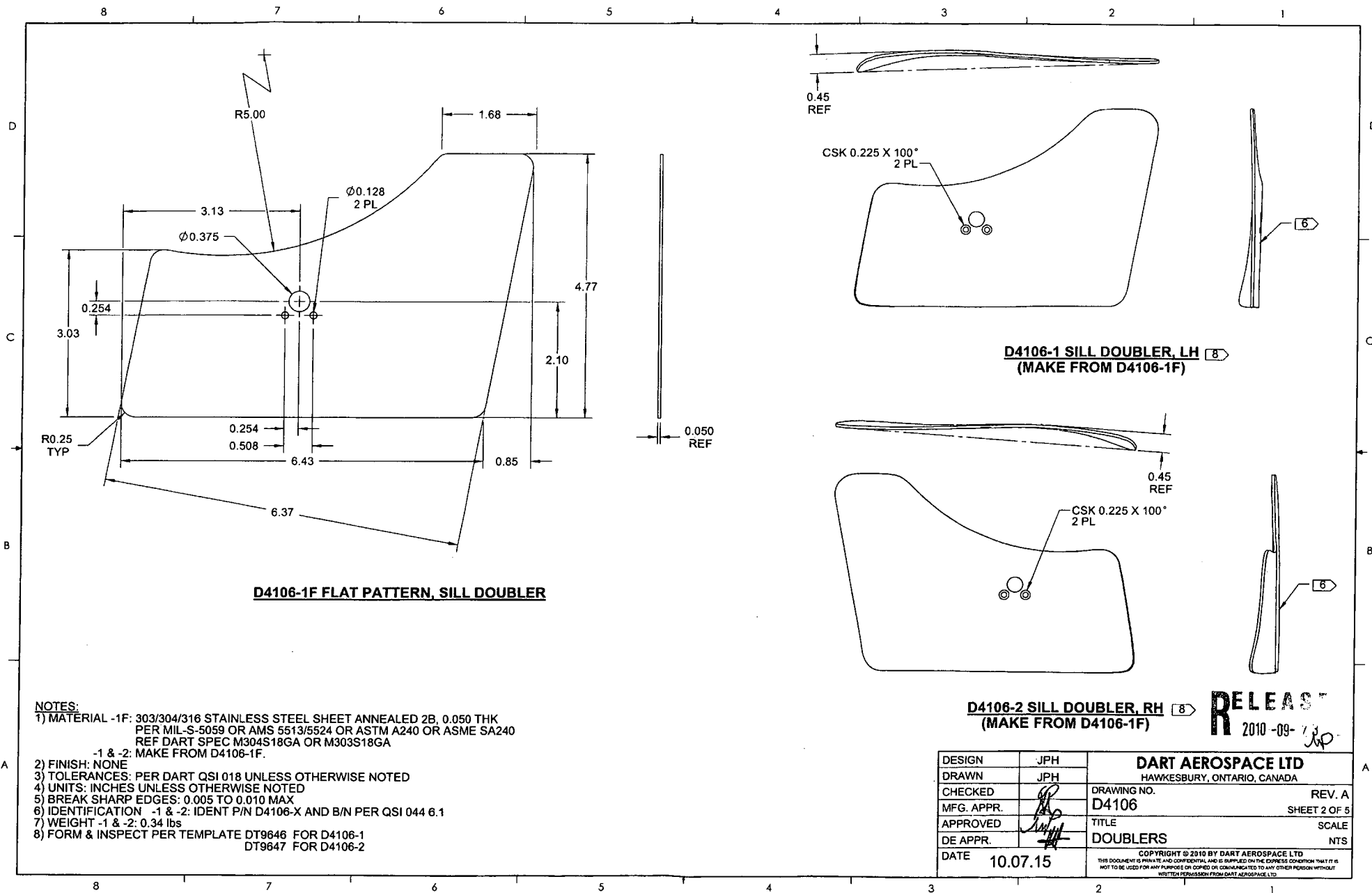
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NOTE: Date & initial all entries

79342



D4106-1F FLAT PATTERN, SILL DOUBLER

NOTES:

- 1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S18GA OR M303S18GA
-1 & -2: MAKE FROM D4106-1F.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -1 & -2: IDENT P/N D4106-X AND B/N PER QSI 044 6.1
- 7) WEIGHT -1 & -2: 0.34 lbs
- 8) FORM & INSPECT PER TEMPLATE DT9646 FOR D4106-1
DT9647 FOR D4106-2

D4106-2 SILL DOUBLER, RH (MAKE FROM D4106-1F)

RELEASE
2010-09-13

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D4106	SHEET 2 OF 5
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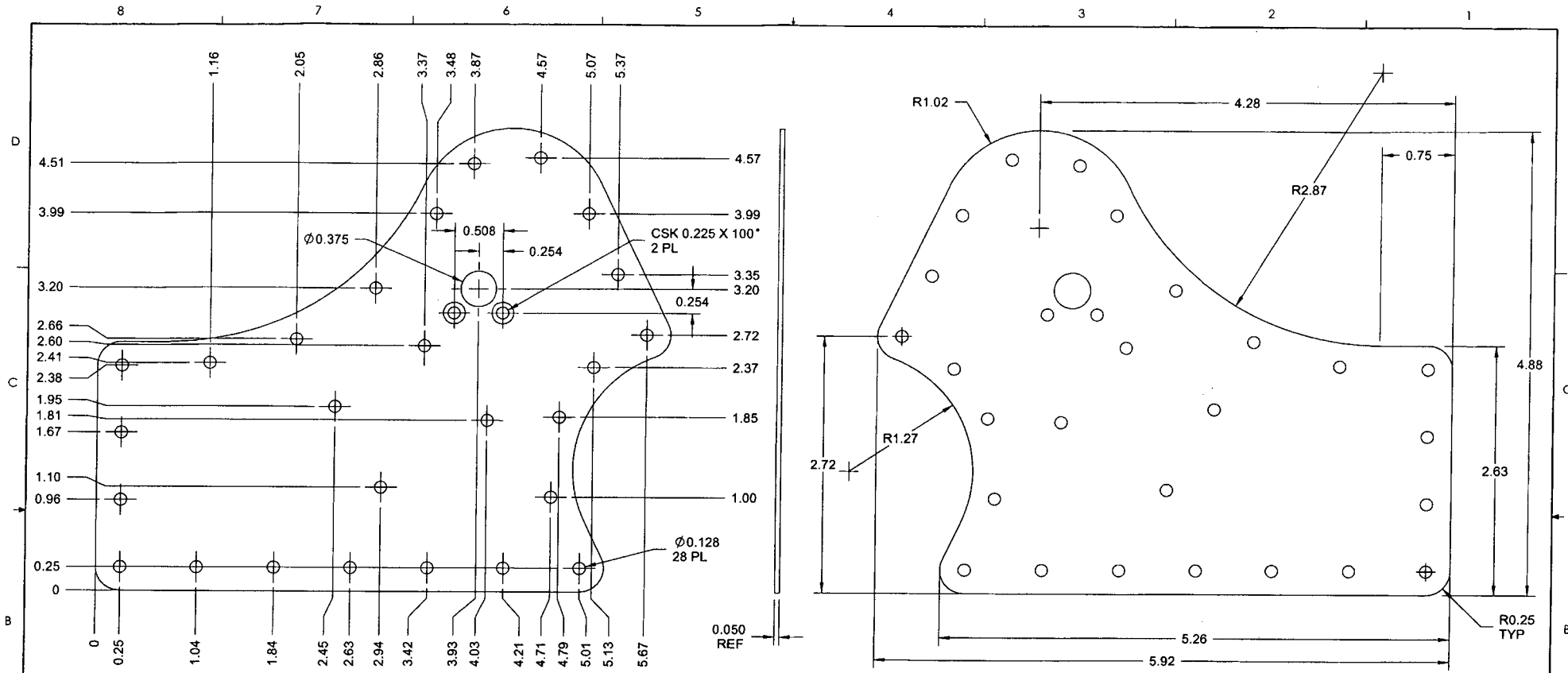
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79342



D4106-3 CREW DOOR DOUBLER, LH

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA OR M303S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-3 AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.27 lbs

RELEASED
2010-09-23

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4106	SHEET 3 OF 5
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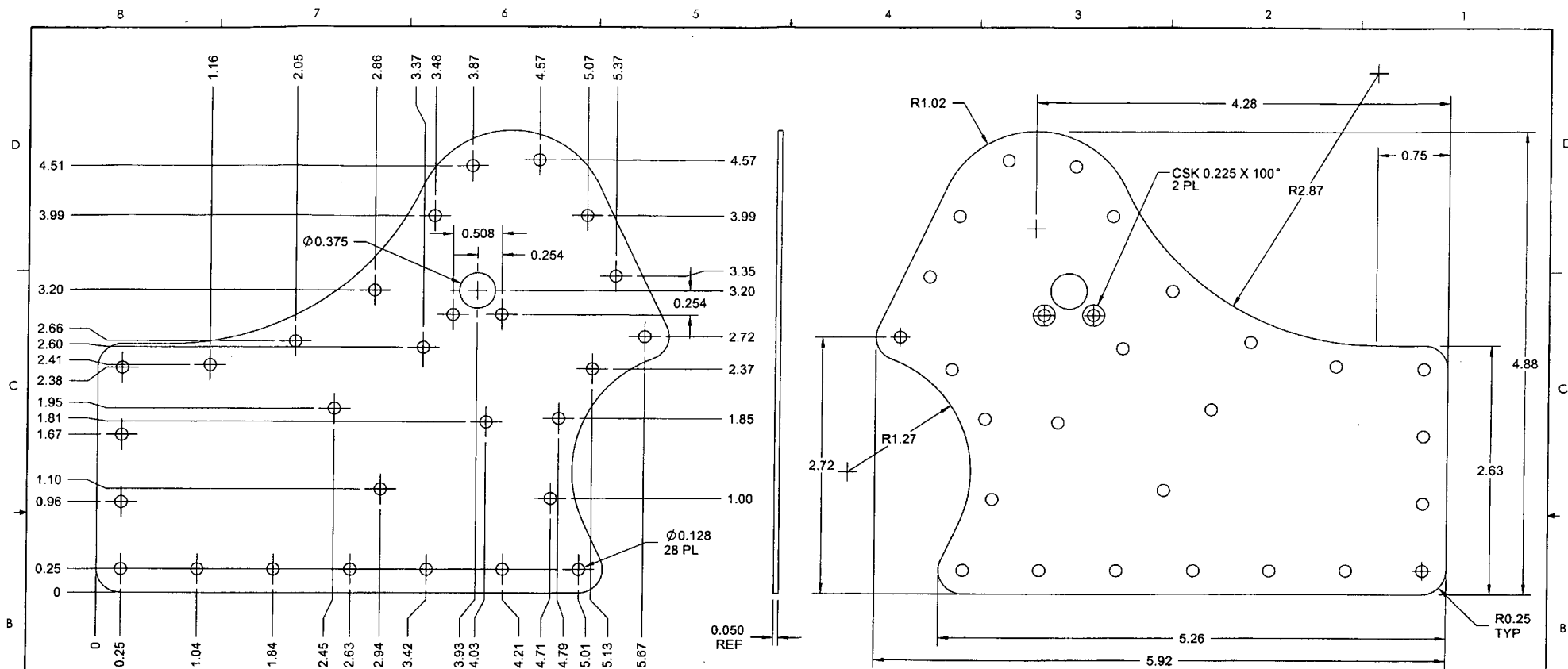
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79342



D4106-4 CREW DOOR DOUBLER, RH

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA OR M303S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-4 AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.27 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4106	REV. A
MFG. APPR.	<i>[Signature]</i>	TITLE DOUBLERS	SHEET 4 OF 5
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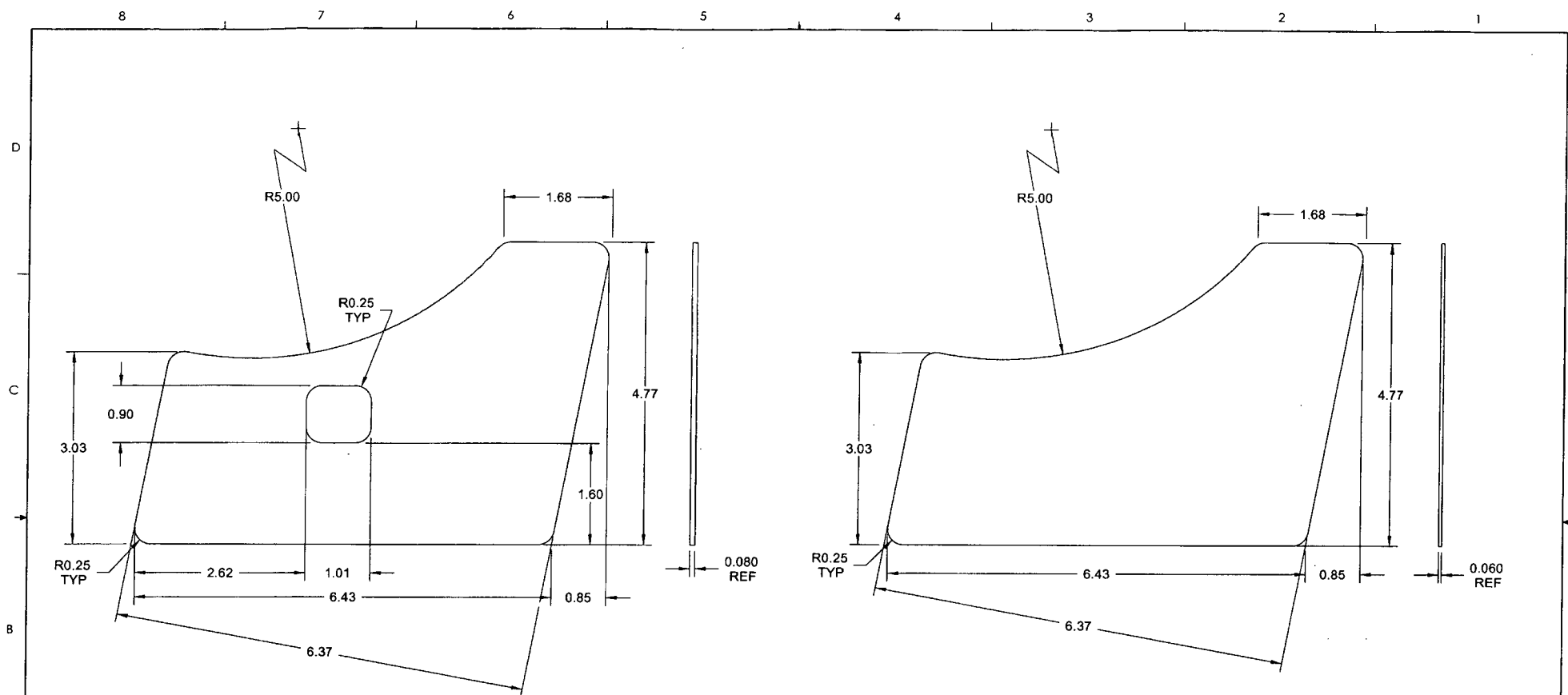
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D4106-5 SPACER, SILL DOUBLER

D4106-7 TEMPLATE

NOTES:

- 1) MATERIAL -5: KYDEX 6185 SHEET, 0.080 THK
REF DART MKYD6185S.080-P3-52068 OR MKYD6185S.080-P3-62015
- 7: LEXAN 9034 SHEET, 0.060 THK
REF DART MLEXS.060-9034-08
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.
REF DART M-ACRYLIC-S.060
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-X PER QSI 044 6.1
- 7) WEIGHT -5: 0.08 lbs
-7: N/A

RELEASED
2010-09-23
JPH

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D4106	SHEET 5 OF 5
APPROVED	JPH	TITLE	SCALE
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